Qty:

User:

Friday, 2/17/2006 10:29:53 AM

Linda Lacelle

### **Process Sheet**

Customer **Job Number**  : CU-DAR001 Dart Helicopters Services

: 25879

**Estimate Number** P.O. Number

: 10845

First Issue

**Previous Run** 

: NIA

This Issue Prsht Rev.

: 2/17/2006

: NC

: 24885

: 2/17/2006

: MACHINED PARTS

Written By Checked & Approved By

Comment

04.09.28

New issue KJ/JLM

COMMENT BELOW

S.O. No. : NIA

**Part Number** 

**Drawing Name** 

: D32833 : D3283 REV A

**Drawing Number Project Number** 

: N/A

: DOUBLER

: A **Drawing Revision** 

:NIA Material **Due Date** 

: 2/24/2006

40 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

1.0

2.0

3.0

**Machine Or Operation:** 

**Description:** 

M6061T6S080

6061-T6 .080 Sheet

Comment: Qty.: 0.3465 sf(s)/Unit Total:

6061-T6 .080 Sheet

Material: 6061-T6 (QQ-A-250/11) 0.080" thick

(M6061T6S.080) Identify for D3283-3

SHEAR

13.8600 sf(s)

Comment: SHEAR

HAAS1

SHEAR

Cut blanks: 15.550" x 2.450

HAAS CNC VERTICAL MACHINING #



Comment: HAAS CNC VERTICAL MACHINING #1 .

Machine as per Folio FA424 and Dwg D3283

Stack of 10

Identify as D3283-3

INSPECT PARTS AS THEY COME OFF MACHINE

40

210

4.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40

5.0 QC8 SECOND CHECK



40

Comment: SECOND CHECK

# **Dart Aerospace Ltd**

EP	PROCEDURE CHANGE					
		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _	PAR #:	Fault Category:	NCR: Yes No DQ	A: Date: 06/02/6
			QA: N/C Close	d: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC Corrective Action Section B			Description of NC Corrective Action Section B		Verification	Annroyal	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
06/02/18	3	12 pieces scrap the #40 drill broke inside the piece	1 Designation	Action Description  Chief Eng  destroy and replace	ml 06/02/18	unge	VB STUD	06 er 20	
				•					

NOTE: Date & initial all entries

Friday, 2/17/2006 10:29:53 AM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: DOUBLER** Job Number: 25879 Part Number: D32833 Job Number: --Seq. #: **Machine Or Operation: Description:** PACKAGING 1 6.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 419 C 206/02/20 7.0 DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

# **Dart Aerospace Ltd**

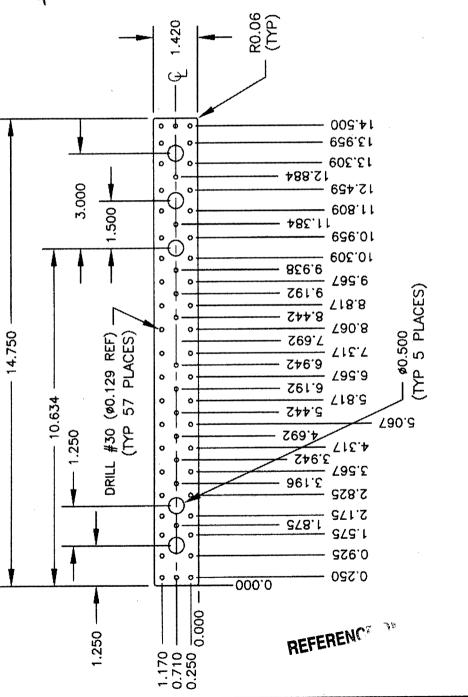
W/O:		WORK ORDER C	HANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:		
			′ QA: I	N/C Close	d:	_ Date: _		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	A	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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NOTE: Date & initial all entries



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		dif	一块一	D3283 SHEET 1 OF 2
	DATE			TITLE SCALE
	05.0	8.09		DOUBLER 1:3
	Α		04.05.06	NEW ISSUE
	В		04.08.09	10.882 WAS 11.502
	С		05.03.16	CHANGE HOLE PATTERN FOR -1
	D		05.08.09	REDESIGN



MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART D3283-1 DOUBLER

FINISH: CHEMICAL

SPEC. M6061T6S.063).

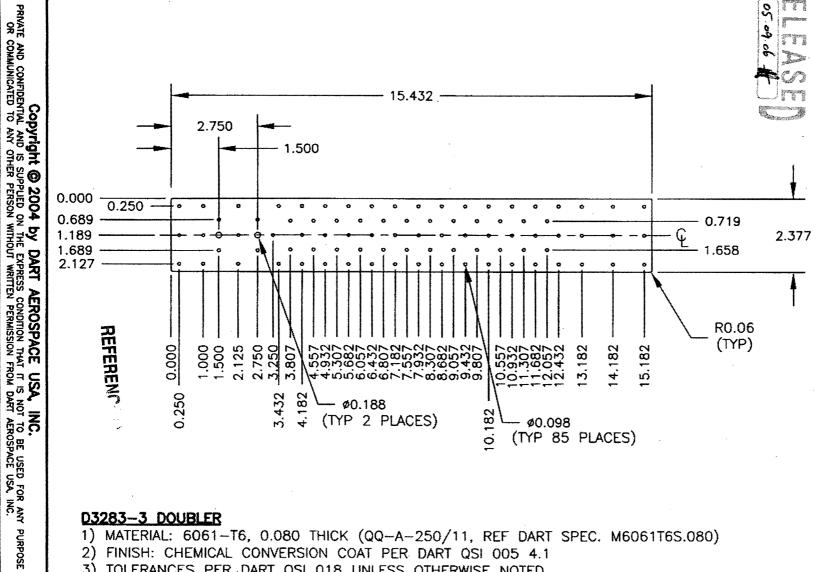
CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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 DESIGN	CP	CP	DART A	DART AEROSPACE USA, INC.	USA,	NC.
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	格	£	D3283		3HS	SHEET 2 OF 2
 DATE			TIME.			SCALE
05.08.09	9		DOUBLER			1:3

## D3283-3 DOUBLER

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DOCUMENT

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COPIED

- MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD		
	Work Order:	25879
Description: DOUBLER	· Part Number:	D3283-3
		03483
Inspection Dwg: D3283 Rev: D		Page 1 of 1

	FIRST	ARTICLE IN	ISPECTION	ON CHE	CKLIST		
		First Artic	cle	Proto	otype		
Drawing	Tolerance	Actual			Method of		
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A	Vew Issue				KJ/RF		v.u

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